

Work Order ID 51459

August 25, 2009 6:42:33 AM



Page 1

Item ID: D2565-107

Accept



Setup Start



Revision ID: E

Stop



Item Name: Strut

Start Date: 8/25/09 Start Qty: 10.00



Cust Item ID:

Required Date: 8/31/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2565

Rev E

100

0.00



NC BRAKE

0.00

Brake NC

Memo

Brake NC

Punch as per Dwg D2565 using DT 8313

88 09/08/26

10 /

110

0.00



Small Fab

0.00

Small Fab

Memo

Small Fab

Debur

M.H 09/08/31

(10X)

120

0.00



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

27 09/09/01

(410)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51459

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Page 2

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Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

0.00

START TIME:

11:30 AM

FINISH TIME:

OVEN TEMPERATURE:

400°F

⇒ 11 09/09/02 (10) Ø

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

BR 09-09-2 (10)

150



Packaging

Packaging

Identify as per dwg & Stock Location: ST 270

0.00

Memo

0.00

EB 09/09/04 (10)

Work Order ID 51459

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Page 3

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Required Date: 8/31/09 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC21 - Final Inspection - Work Order Release

0.00

Memo

0.00

09/09/09 *[Signature]*

PL 09-9-04

Picklist Print

August 25, 2009 6:42:33 AM

Work Order ID: 51459

Parent Item: D2565-107RevE

Parent Item Name: Strut

Comments:



Start Date: 8/25/09

Required Date: 8/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	262.0510	11.7800			



304 RD Tube .750 x .049W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

262.0510026

107518	7.27
108498	0
109314	8.5
110113	0.73
110271	0.03
111096	9
111457	11.43
111619	13.2700026
112187	211.821

3.2700026
~~14.000~~ SB 09/28/26 CO
~~14.691002~~
17.2700026

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector





Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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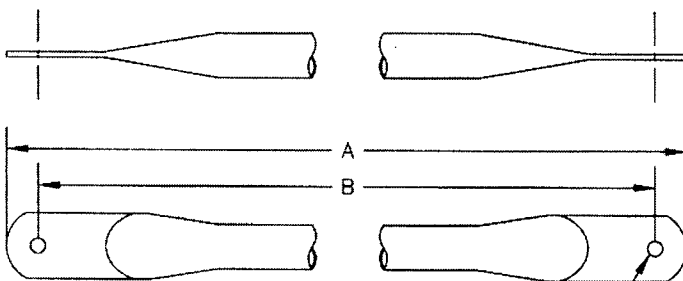
NOTE: Date & initial all entries



DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05			TITLE STRUT SCALE 1:3		
A	96.05.03		NEW ISSUE		
B	97.03.15		CORRECT D2565-111 DIM. A		
C	98.10.05		UPDATED MATERIAL NOTE (TSR A603)		
D	02.06.05		ADD -3XX PARTS; ADD FINISH		
E	04.05.05		ADD D2565-401-411; RMV ANGLE D		

RELEASED
04.05.05

WLO 51459



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TRO.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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